

Work Order ID 60866

Monday, July 26, 2010 11:43:21 AM

Page 1

Item ID: D3537-3

Accept

Revision ID:

Item Name: Wearpad

Start Date: 7/26/2010 Start Qty: 10.00

Required Date: 8/3/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: 14 Date: 10-7-26 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-.

Deburr if necessary SAD 10-07-28

304 . 063

B 10-7-27

(17)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 10-7-27

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S 10/6/28

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				<u>17</u>			
Brake NC	Memo Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 <input type="checkbox"/> Form Joggle as per Dwg D3537 on brake using Jig DT8158	0.00							
140  QC	QC5- Inspect part completeness to step on W/O	0.00				<u>47</u>			
Quality Control	Memo Ensure joggle as per dwg D3429	0.00							
150  Large Fab	Large Fab	0.00							
Large Fab	Memo Qty Description Batch <input type="checkbox"/> A/R 2059B Hardcoat <u>1115553</u> <input type="checkbox"/> Weld hardcoat as per Dwg D3437	0.00							

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Item ID: D3537-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 7/26/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<u>17</u>			
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>17</u>			
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <u>MW2588</u> Memo START TIME: <u>11:45</u> <u>320</u> FINISH TIME: <u>12:15</u>	0.00 0.00				<u>17</u>			

W/O:		WORK ORDER CHANGES					
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Page 4

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 7/26/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

=) 11 10/09/20



QC

Memo

0.00

(17)

9

Quality Control

200

Identify as per dwg & Stock Location

0.00

FP-17 BL 10-9-20



Packaging

Memo

0.00

(17)

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/09/21

Quality Control

ME
10-9-20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 11:43:25 AM

Page 1

Work Order ID: 60866

Parent Item: D3537-3

Parent Item Name: Wearpad



Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

37.8267

0.149

1.568421

2.6



1810-7-27

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

37.82669474

111323

0

114799

37.8266947

114799

(17)

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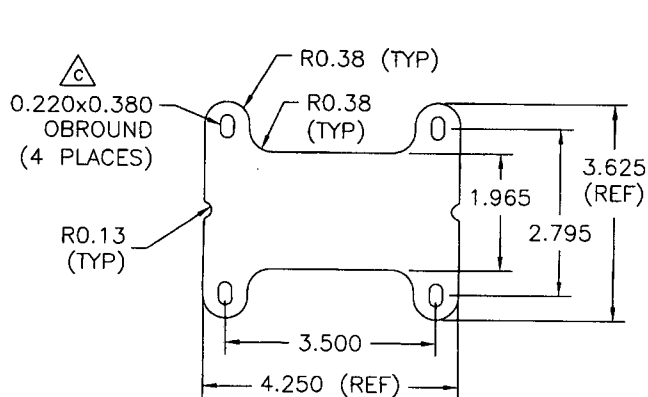
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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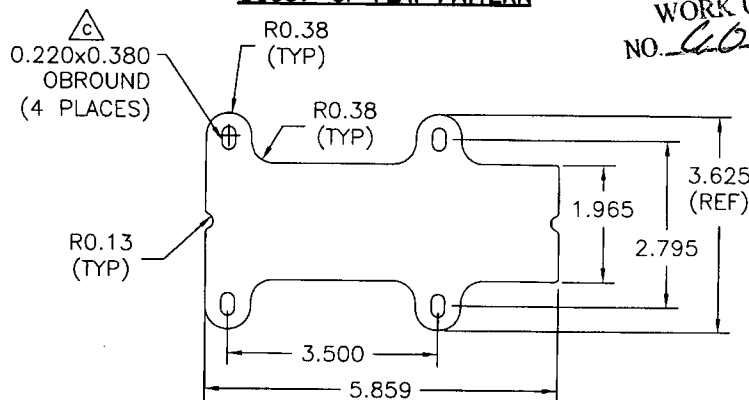
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60866

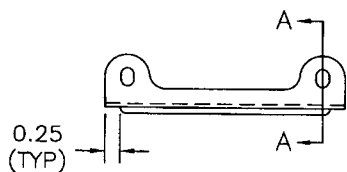
D3537-1F FLAT PATTERN



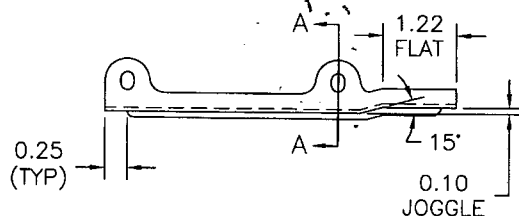
D3537-3F FLAT PATTERN



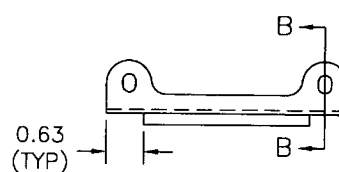
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



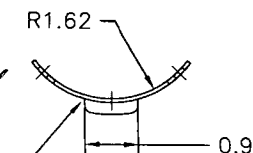
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

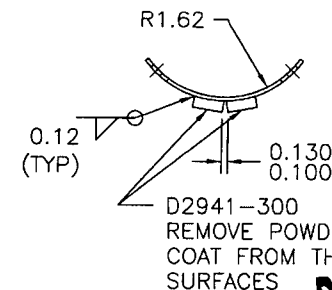


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

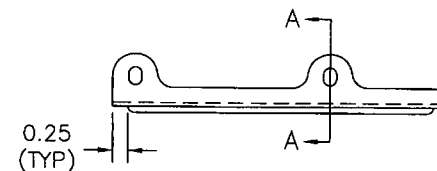
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.03 Ad
per ECU
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
DART AEROSPACE USA, INC.	PORT HADLOCK, MA	SHEET 1 OF 1
		SCALE 1:2

W/O:		WORK ORDER CHANGES					
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